

# Work Order ID 70770

Wednesday, June 15, 2011 9:08:13 AM



Page 1

Item ID: D2935	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Saddle Spacer				
Start Date: 6/15/2011	Start Qty: 40.00		Cust Item ID:	
Required Date: 6/22/2011	Req'd Qty: 40.00		Customer:	
Reference:				

Approvals:	Process Plan: <u>  <i>AS</i>  </u>	Date: <u>  6/15  </u>	Tooling:	Date:	Run Start	
	QC: <u>          </u>	Date: <u>          </u>	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2935	Rev B								
100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	<b>Memo</b>	0.00							
6061 .080	1-Cut as per Dwg D2935								
	Dwg Rev: <u>  <i>BR</i>  </u>								
	Prog Rev: <u>          </u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	<b>Memo</b>	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	<b>Memo</b>	0.00							
Quality Control									

  B11-6-29  

*GP 6/17/04* (5/2) (5/1)

  B11-6-29  

*counted*  
(257)

*8/11/06/29*

**Work Order ID 70770**

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Item ID: D2935

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle Spacer

Start Date: 6/15/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

51 0 BK 11-7-11

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

51X 0 m 11/07/04

150

Identify as per dwg &amp; Stock Location: 27

0.00



Packaging

Memo

0.00

Packaging

11/7/48 (310)

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Item ID: D2935

Accept



Setup Start



Revision ID:

Item Name: Saddle Spacer

Stop



Start Date: 6/15/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



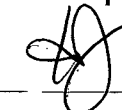
QC

Memo

0.00

Quality Control

11/7/4



CL11107104

# Picklist Print

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Page 1

Work Order ID: 70770



Parent Item: D2935



Parent Item Name: Saddle Spacer

Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP A□00.06.06□New Issue□EC□  
IPP Rev:B Now 6061-T6 06-06-23 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.080

Purchased

No

100

sf

256.5000

0.0507

2.134737

3.



FB11-6-29

6061-T6 .080 Sheet

Location

Loc Qty

Loc Code

MAT021

256.5

116268

33.5

117285

223

117285

FS



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

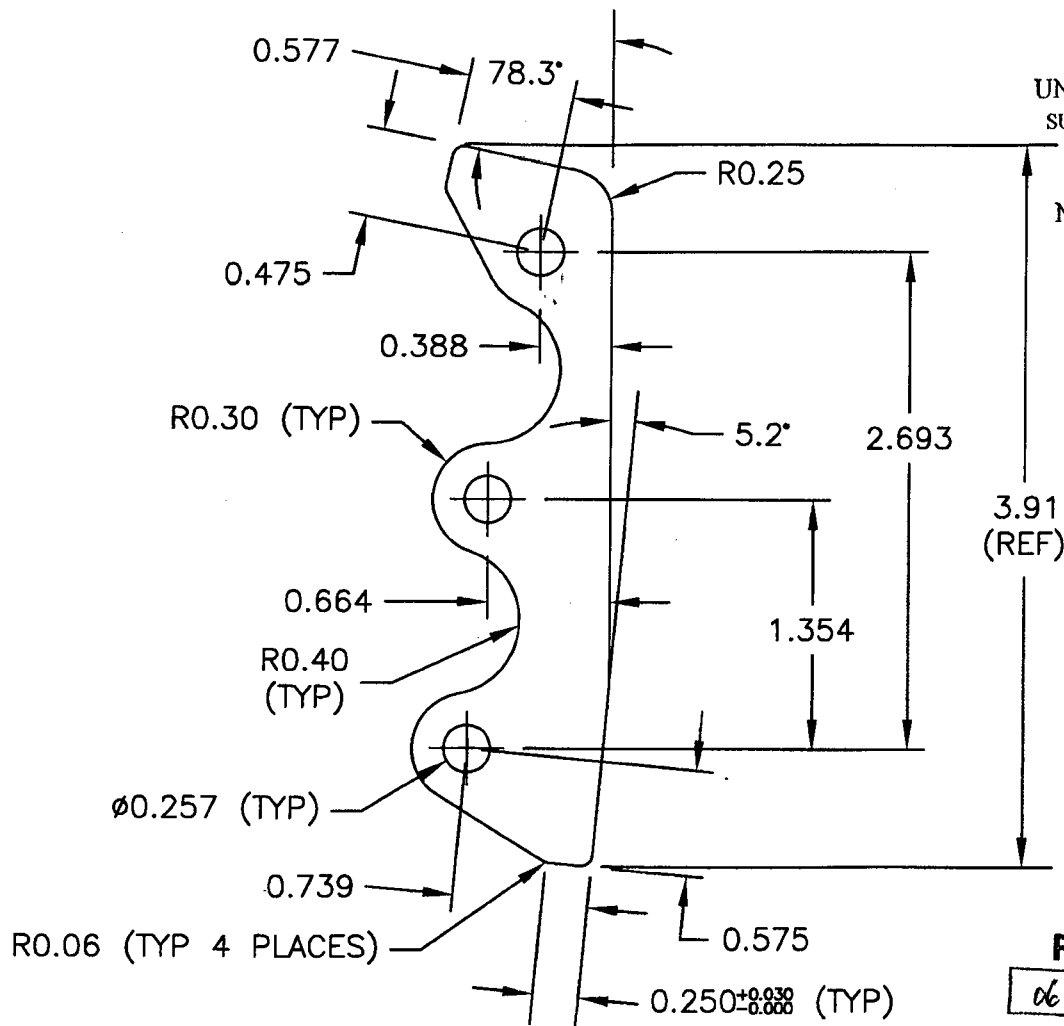
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN 77	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED <i>[Signature]</i>	DRAWING NO. D2935	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SADDLE SPACER	SCALE 1:1
A	99.11.02	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 70770

11-05-15

RELEASED

06 06 20

**NOTES:**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries